

Date: Tuesday, 3/20/2007 1:51:31 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD X-TUBE
Job Number	: 31364		
Estimate Number	: 10006		
P.O. Number	: <i>N/A</i>	Part Number	: D2889
This Issue	: 3/20/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2889 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 31350	Material	: <i>N/A</i>
Written By	:	Due Date	: 4/10/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>07.03.20</i>		
Comment	: Est Rev A New Issue 05-10-25 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube material

Pick:

Qty Part number Description Batch

1 D2889 Fwd Crosstube *25673**EL 7-3-27*

2.0	BENDING	BENDING MACHINE
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Comment: LANDING GEAR RESOURCE 1

1-Bend D2889 as per Dwg D2889 and Folio FT001

*EL 07-03-27*

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

*N/A*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

*0703-28 ①*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1

Inside and outside of tube

*N/A*

*See Attached  
dim sheets*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: h2 Date: 07/03/29

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:51:31 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 31364

Part Number: D2889

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

See ATTACHED  
DIM SHEET

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



U 07-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

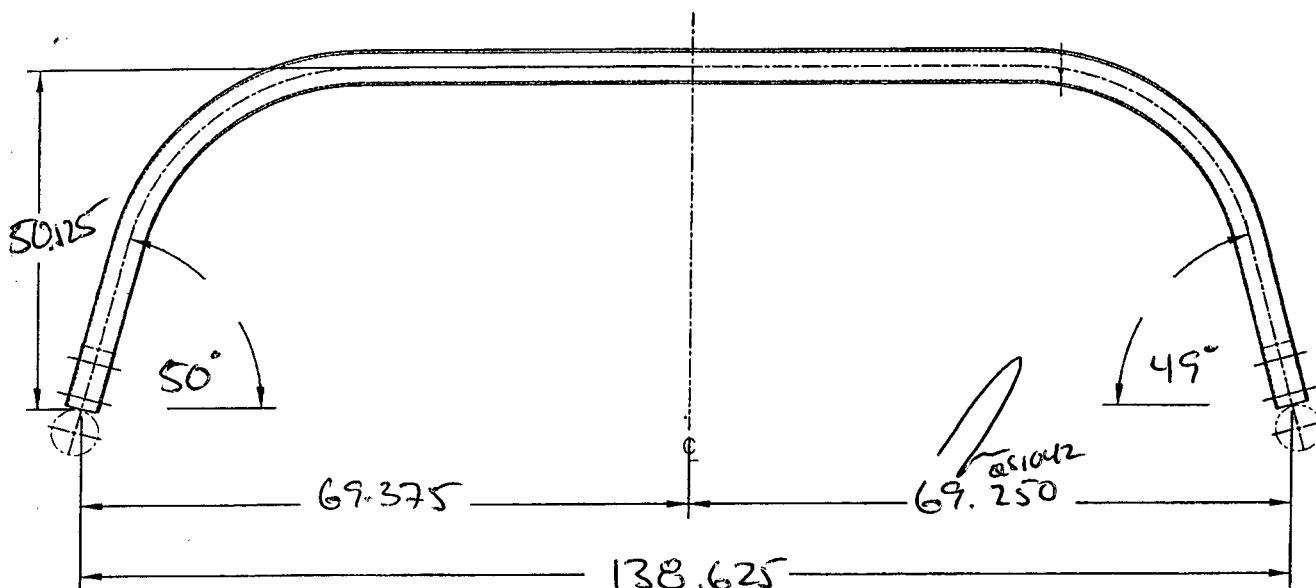
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31364
Description: Crosstube Fwd		Part Number:	D2889
Inspection Dwg: D2889		Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
Tube for w/o 31372 D205-596-101

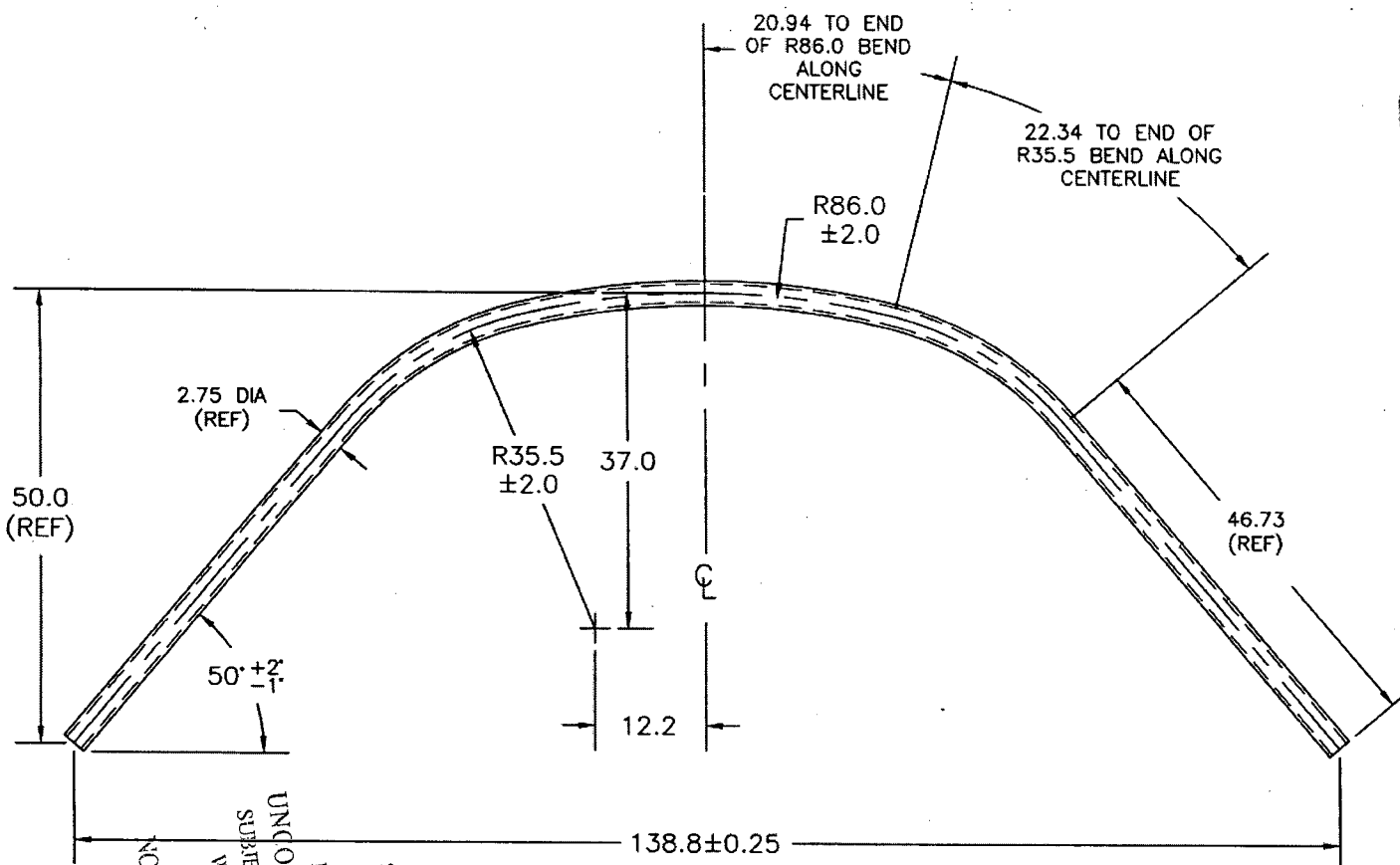
QC15 Inspection	AS1642
Date	0703-28

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>



RELEASED  
02.10.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		DATE		D2889	
02.10.18		02.10.18		SHEET 1 OF 1	
A		99.05.21		REV. B	
B		02.10.18		SCALE	
		ADD TANGENT LENGTHS: CHANGE NOTES		1:20	
		FWD CROSSTUBE			
		NEW ISSUE			
		HAWKESBURY, ONTARIO, CANADA			



#### NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 (ø2.75 OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.